

Work Order ID 76493

76493

Page 1

Tuesday, November 15, 2011 3:58:12 PM

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 11/15/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/25/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference: Run Start ***NR1***
 Stop ***NR2***
 Approvals: Process Plan: Date: 11-11-15 Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3324	Rev B

100 0.00
100 Large Fab
 Large Fab
 Large Fab

Memo

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	109127
4	D3324-3	Full Length Tube	109127
2	D3324-5	Top End Tube	109127
2	D3324-7	Bottom End Tube	109127
10	D3324-9	Vertical Tube	109127

2- Weld as per dwg

A/R 4130 rod batch: 118875

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC
 Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
121	Pressure Wash per QSI005 4.3	0.00							
121									
HandFinish	Memo	0.00							
Hand Finishing									

IX DM 11/14/25

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							

130

Powdercoat
Powder Coating

Memo

1ST COAT: 9:40 400 OF
 START TIME: _____
 OVEN TEMPERATURE: _____
 FINISH TIME: 12:18
 ***** 2nd coat if necessary *****
 2ND COAT: 10:20 400 OF
 START TIME: _____
 OVEN TEMPERATURE: 10:50

Handwritten signature: M. J. M. 11/14/25

140

QC3- Inspect Part Finish

0.00

140

QC
Quality Control

Memo

0.00

Handwritten signature: 11-11-28

Handwritten: M118434

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
150									
Packaging	Memo <i>w/o</i>	0.00							
Packaging	<i>76489</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/11/28 *(1)*

11/11/29

MF
11-11-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Tuesday, November 15, 2011 3:58:17 PM

Work Order ID: 76493

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Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.02.09New issueKJ/JLM

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 *D3328-3* Basket Hinge		Manufactured	No			100	Each	18.0000	2	2		11/11/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				18					
				33872				18					
D3348-1 *D3348-1* Clevis		Manufactured	No			100	Each	15.0000	4	4		11/11/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
				75575				14					
				WA005				1					
				44246				1					
D3349-3 *D3349-3* Spacer Bushing		Manufactured	No			100	Each	4.0000	2	2		11/11/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
				72930				4					
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	8.0000	2	2		11/11/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				8					
				43228				8					

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Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035 Purchased No

100 f

307.3682 46.6 49.05263

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

Pl 11.11.24

Location

Loc Qty

Loc Code

MAT034

307.3682

109127

158.152

109385

15.75

112786

39.2488

119441

57.8774

119506

36.34

49.05263

M569EX0.50-18F Purchased No

100 sf

146.0000 28 28

M569EX0 50-18F

569 Expanded Metal

**

11/11/21

Location

Loc Qty

Loc Code

MAT018

146

112776

10

117806

4

119226

4

119404

128

32

W/O:		WORK ORDER CHANGES					
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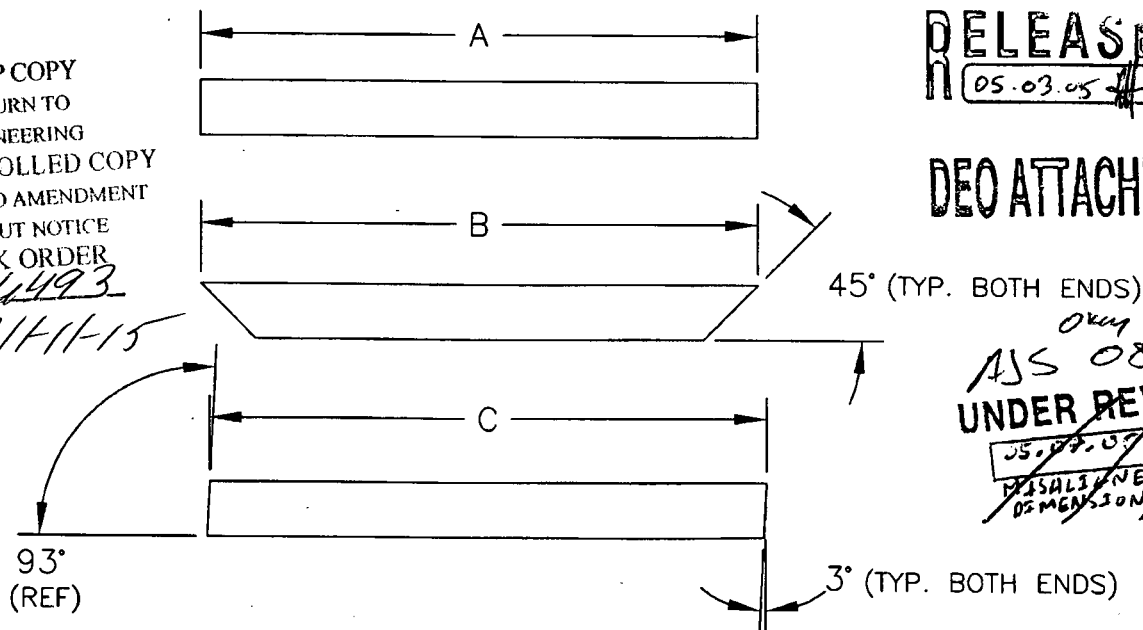


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74493



RELEASED
05.03.05

DEO ATTACHED

45° (TYP. BOTH ENDS)

OK'd
JSS 08.12.15
UNDER REVIEW
05.07.05 PH
DISALIGNED
DIMENSION PG 2

93°
(REF)

3° (TYP. BOTH ENDS)

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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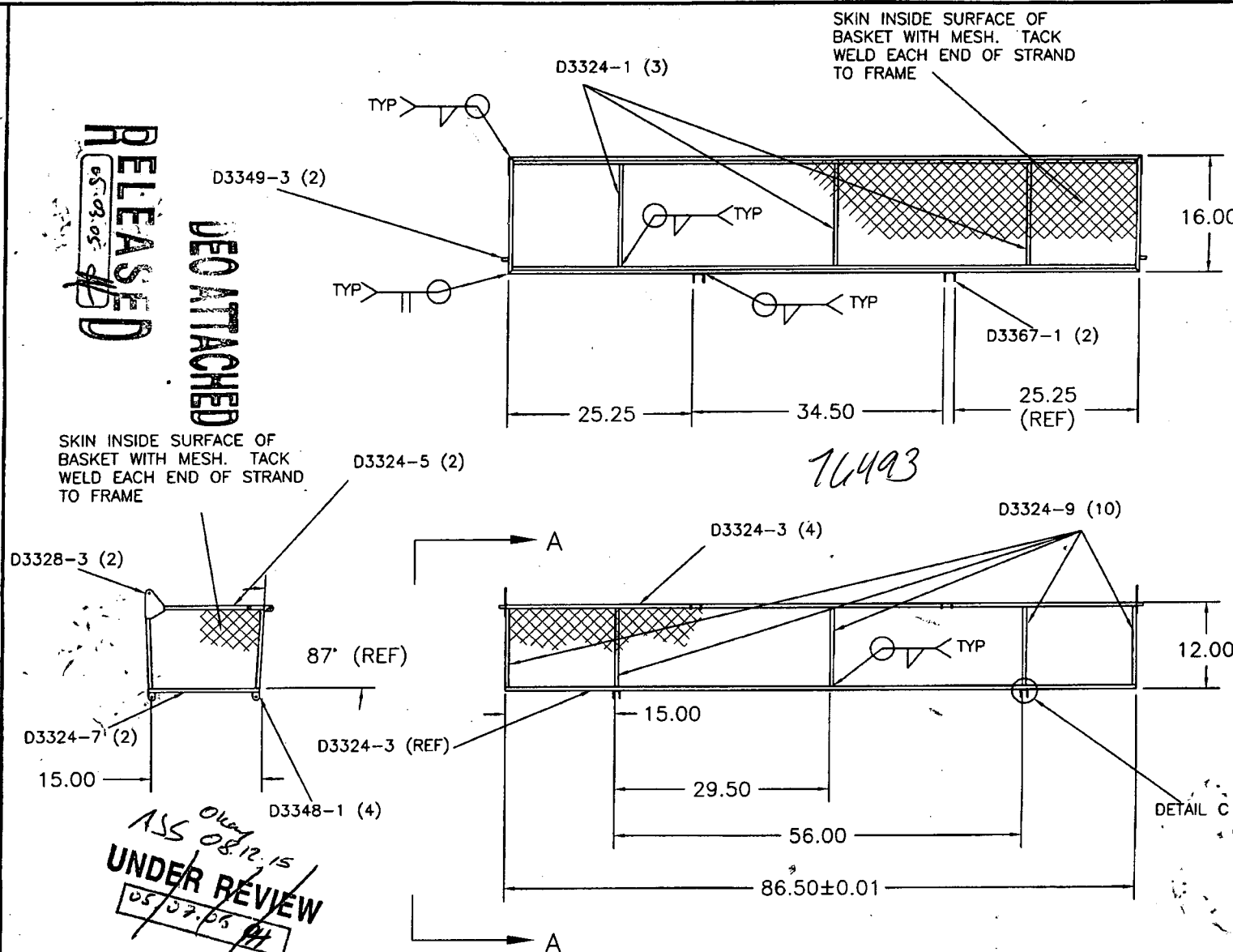
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.03.04	D3324	SHEET 2 OF 3
	TITLE	SCALE
	BASKET BASE ASSEMBLY	1:20



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

WPA.

LIFE | STEP

1957 年 1 月 1 日 14 日。

- 1 -

Adult Category

NCR: Yes No **DQA:** _____ **Date:** _____

11000000

disposition

QA: N/C Closed: _____ Date: _____

FIG. 2.

WORLD-ORIENTED NON-CONFORMANCE (NCR)

DATE _____ INDEX _____

RECEIVED: 1977
1978

Initial
and 21 Day

Constructive Action Section B

Action Description

Chief Eng

**Sign &
Date**

Verification

Section C

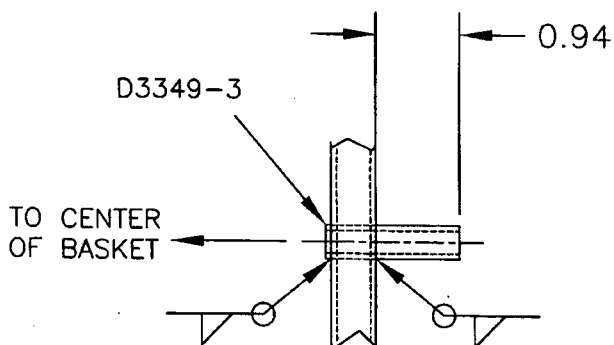
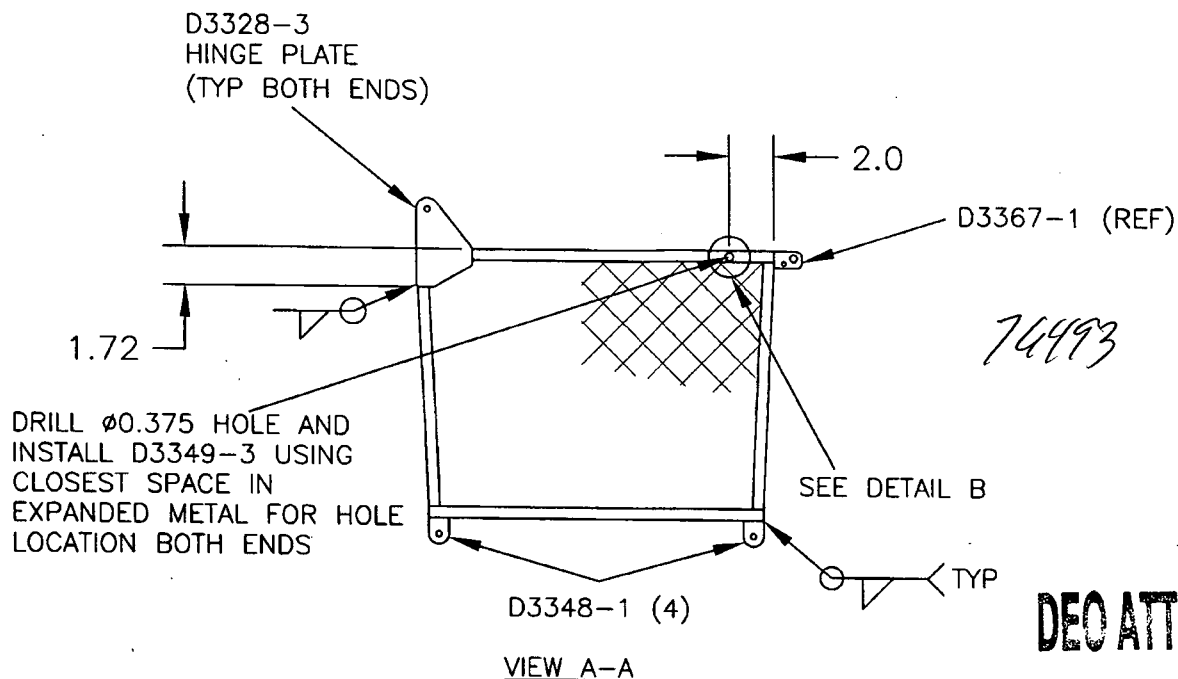
Approval
Chief Eng

Approval
QC Inspector

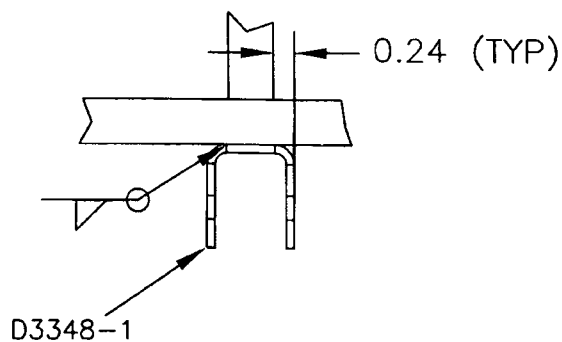
NOTE: Date 3. Initials of officer

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



DETAIL B
(SCALE 1:2)



DETAIL C
(SCALE 1:2)

Ok
ASS 08.12.15
UNDER REVIEW
05.03.06

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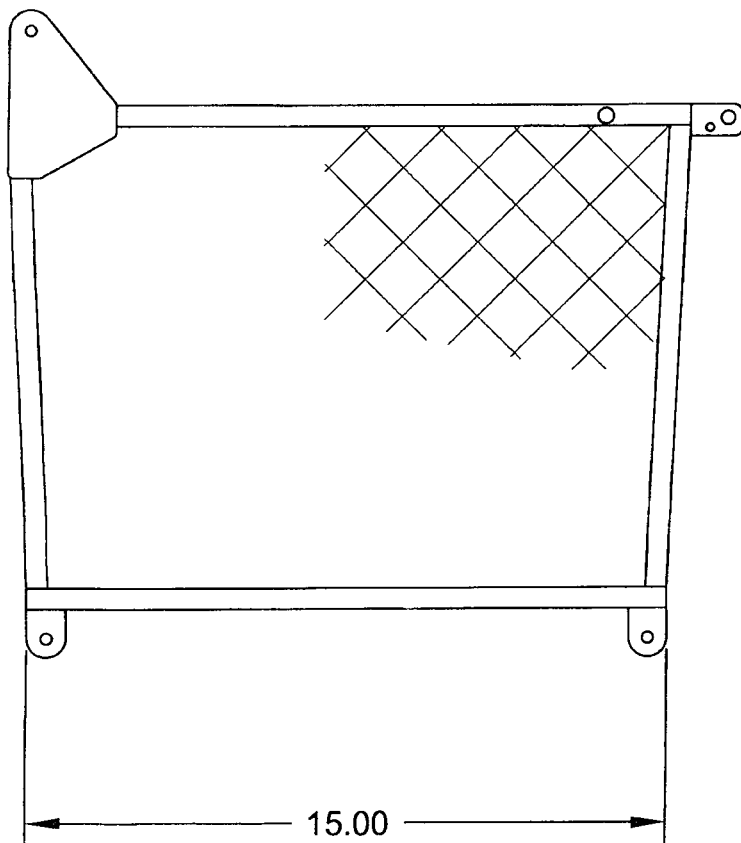
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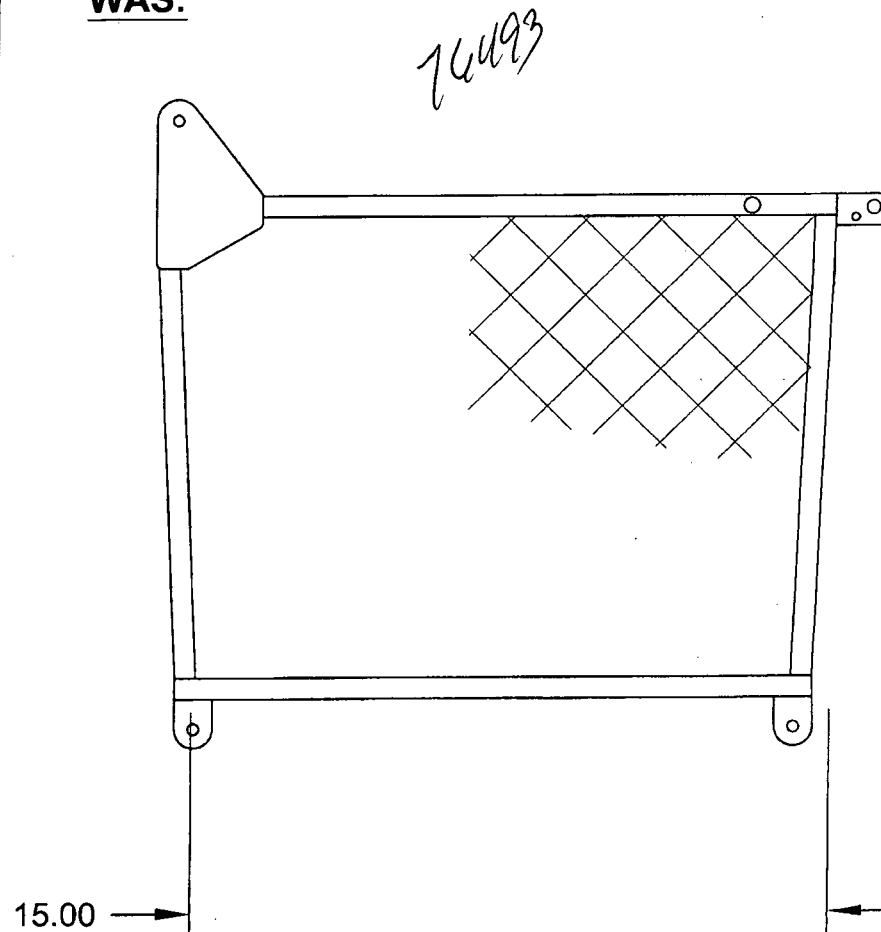
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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